

Work Order ID 139578

139578

Page 1

Monday, November 30, 2015 11:08:13 AM

Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Vertical Reference Window
 Start Date: 11/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: DEC 02 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	B								
100	Document Control	0.00							MLJ APR 07 2016
100									DAS 27 9-82
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels for PPP D412-711-101 Change 002								APR 07 2016
110	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89 14/04/06
110									
HandThermo	Memo	0.01							14/02/10
Hand Finishing Thermoforming	Set up Machine as per folio FTA 077 and D711W program using mould DT9640								
120	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89 14/04/06
120									
HandThermo	Memo	0.01							14/02/10
Hand Finishing Thermoforming	Cut Blanks to 37.5" by 43"								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Monday, November 30, 2015 11:08:13 AM

Page 2

Reference: [2](#), [4](#)

Stop ***NR2***

- 1) Trim off excess flange material
- 2) Buff out any light scratches or blemishes
- 3) Etch part number and batch number

**DAS
07
9-89**

16/04/06

DQA:

Date: 16.04.13



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/04/11

Work Order update only ☐

Work Order: <u>139578</u> Part No. <u>0412-711-101</u> NCR No. <u>16-5702</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☒</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☒	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>16/04/06</u>		Step #: <u>100</u>		QTY Effective: <u>81</u>		MRB (QS1042) Approval DAS 16 9-89 <u>16/04/06</u>																																																																	
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PART TORN DURING FORMING. PROCESS.				FILE SHARP EDGE ON MOLD. SCRAP ONE PART & Replace																																																																			
				Completed By <u>DAS</u> <u>16/04/06</u> <u>07</u> <u>9-89</u> Lead hand / Supervisor Approval Verification <u>16/04/11</u> <u>DAS</u> <u>16/04/06</u> <u>07</u> <u>9-89</u> QC / QA Coordinator DAS Approval <u>16</u> <u>9-89</u> <u>16/04/06</u>																																																																			
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OTHER: <u>Tooling</u>																																																																							

Work Order ID 139578

Monday, November 30, 2015 11:08:13 AM

139578

Page 3

Item ID: D412-711-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Vertical Reference Window

Stop

NS2

Start Date: 11/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC2- Inspect parts off machine FAI/FAIB

0.00

170

QC

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

X

DAS
07
9-89

12/07/06

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

(81)

DAS
16
9-89

12/04/07

185

QC4- 100% Inspect kits for completeness

0.00

185

QC

Memo

0.00

Quality Control

DAS
27
9-89

APR 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Work Order ID 139578

Monday, November 30, 2015 11:08:13 AM

139578

Page 4

Item ID: D412-711-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Vertical Reference Window

Stop

NS2

Start Date: 11/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

Sold

0.00

190

Packaging

Memo

0.00

Packaging

Location : FG099

SAS
27
9-89
APR 07 2016

DAS
28
9-89

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

ML5 *APR 07 2016*

ML5 *APR 07 2016*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, November 30, 2015 11:08:12 AM

Page 1

Work Order ID: 139578

139578

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 11/24/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	117.1833		21.33333			DAS
MACRI ICS 236									**				07
Plexiglass G 0.236"													

Location	Loc Qty	Loc Code
MAT	10.66	
M133439	10.66	
therm	106.523333	
M132743	106.523333	

134781

16 sq ft
16 sq ft.

16/02/10

DAS
07
9-89

16/04/06.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
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Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

DART AEROSPACE LTD		Work Order:	139578
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

DAS

Measured by: 07
9-88

Date: 11/04/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.00"	✓			
1.98 <u>N/A</u>	+/-0.030					
1.50	Min	1.53"	✓			
0.090	Min	0.097"	✓			
0.070	Min	0.091"	✓			
0.050	Min	0.062"	✓			
15.0	+/-0.5	15.375"	✓			

DAS

Measured by: 07
9-88

Date: 16/04/06

Audited by: 16
9-88

Date: 16/04/06

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ	

